



Date: Thursday, 10/08/2006 10:02:04 AM
User: Linda Lacelle

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : ASPIRATOR BODY
Job Number : 28133	
Estimate Number : 11975	
P.O. Number : N/A	Part Number : D2094
This Issue : 10/08/2006 S.O. No. : N/A	Drawing Number : D2094 REV A
Prsht Rev. : NC	Project Number : N/A
First Issue : N/A Type : SMALL / MED FAB	Drawing Revision : A
Previous Run : N/A	Material : N/A
Written By : 	Due Date : 31/08/2006 Qty: 25 Um: Each
Checked & Approved By : 	
Comment : Est. B 99.01.20 Re-format DM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
----------------	------------------------------	----------------------

1.0	D2061	Aspirator
-----	-------	-----------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 25.0000 Each(s)

Aspirator

Pick:

Qty	Part number	Description	Batch
1	D2061	Aspirator Body	28138

2.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
-----	-------------	-------------------------------



Comment: SMALL & MEDIUM FAB RESOURCE 1

Drill 4 flange holes as per Dwg D2092/93/94using Drill Jig DT 8262

Cut edges as per Dwg D2095 using Jig DT 8263

Drill 5/16 hole for jet as per Dwg D2092/93/94using Drill Jig DT 8296

Deburr

Clean and polish with water and thinner

FF 06.09.20 25

FF 06-11-02 25

3.0	QC5	INSPECT WORK TO CURRENT STEP
-----	-----	------------------------------



Comment: INSPECT WORK TO CURRENT STEP

12/06/11/02 25

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☐ No ☒ DQA: ☒ Date: 06/11/03
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 10/08/2006 10:02:05 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: ASPIRATOR BODY

Job Number: 28133

Part Number: D2094

Job Number:



Seq. #:

Machine Or Operation:

Description :

4.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

57214

U4/11/02 28

5.0

DC

DOCUMENT CONTROL



25

Comment: DOCUMENT CONTROL

Inspection Level 21

06/11/03

Job Completion



U 06/11-03

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

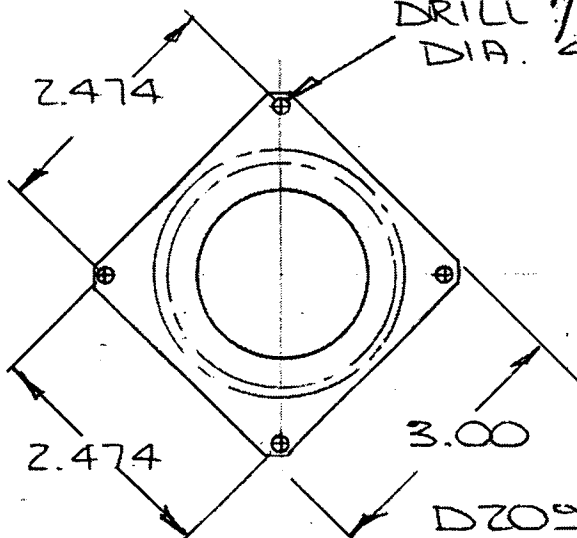
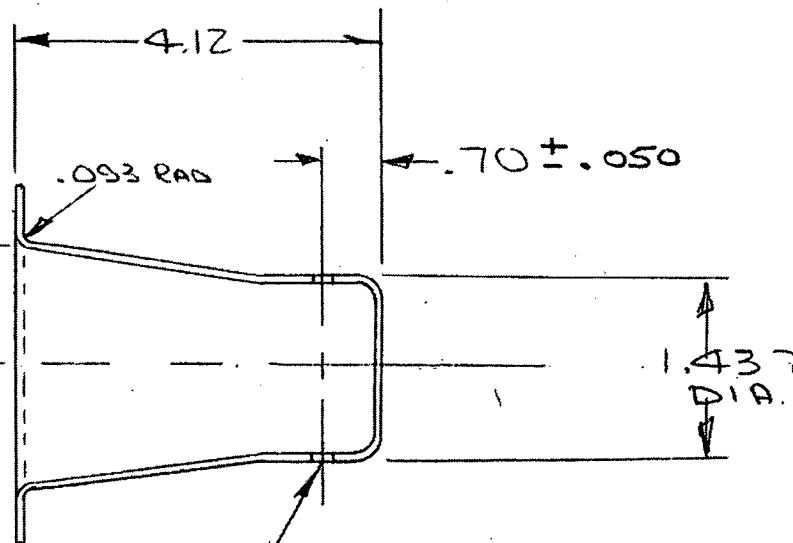
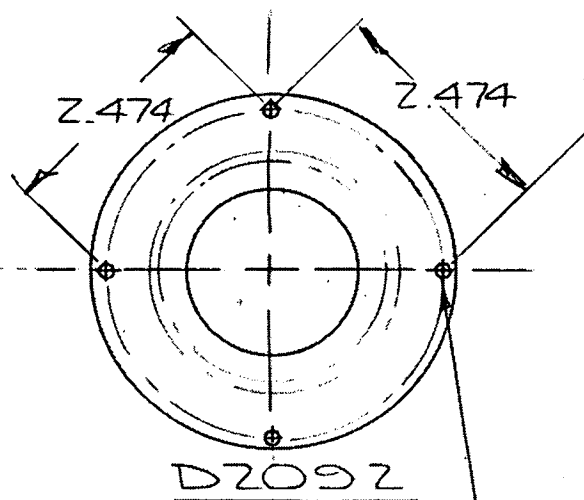
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

RELEASED
09.09.15
RBAV



DRILL 1/4 (.250) DIA. 4 HOLES

DRILL 5/16 (.312) DIA THRU AS SHOWN ON DZ092 AND DZ093. ROTATE 45° ON DZ094.

MATERIAL: 1100-O, .063
SPIN FROM SHEET STOCK

A	REVISION	THIS DRAWING IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT THE PERMISSION OF DART AERO.	RIVET CODE SHALL BE PER NAS 623		PART NO.	ITEM	DESCRIPTION	MATERIAL	SPEC/VENDOR
	DRAWN		BASIC CODE	QIA DASH NO.	CONTRACT NO.	DART AERO ACCESSORIES INC. VANCOUVER CANADA			
	APPROVED		D-DIMPLE D-DIMPLE D-DIMPLE D-DIMPLE	QIA DASH NO. P-HEAD FAR SIDE	DATE				
	DESCRIPTION OF CHANGE		<p>1. DIMENSIONS ARE IN INCHES</p> <p>2. SURFACE FINISH: 125</p> <p>3. RESIDUE SHARP EDGES .015 MAX</p> <p>4. THREADS PER INCH - E - 7742</p> <p>5. HOLES PER AND 10287</p>	<p>1. TOLERANCES - .001</p> <p>2. ANGLES - 100°</p> <p>3. PARALLELISM - .005</p> <p>4. ECCENTRICITY - .005</p> <p>5. SYMMETRY ABOUT ALL M/C CENTRE LINES .005</p>	<p>B-P-1520410AD</p> <p>BB-1520412AD</p>	<p>DESIGN</p> <p>STRESS</p> <p>CHECKED</p> <p>CLIENT</p>	<p>SCALE</p> <p>1:2</p>		

REPORT ALL DISCREPANCIES - DO NOT SCALE

DZ092/3/4

A

COPY 155

DZ092/93/94 A

